



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-742-043
Job Sheet 196371



Part No: D412-742-043

Job Qty: 1 pcs

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/12/19

Job Tracking No:

Due Date: 6/26/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3391-043 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg
@ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM IPP
Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DS19517 REV.B DD verified by:EC
IPP REV:G 16.05.02 AS PER DWG REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Handfinish - 4 - Assembly	1 pcs	6/26/19	6/26/19	0.00	3.50	Handfinish - 4 - 1		M 19-6-17
							Handfinish - 4 - 10		
							Handfinish - 4 - 11		
							Handfinish - 4 - 12		
							Handfinish - 4 - 13		
							Handfinish - 4 - 14		
							Handfinish - 4 - 15		
							Handfinish - 4 - 2		
							Handfinish - 4 - 3		
							Handfinish - 4 - 4		
							Handfinish - 4 - 5		
							Handfinish - 4 - 6		
							Handfinish - 4 - 7		
							Handfinish - 4 - 8		
							Handfinish - 4 - 9		
120	QC 5	1 pcs	6/26/19	6/26/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S191013



Part: D412-742-043

Job No: 196371

Serial No/Batch: S191013

Revision: AJJ

Inspector:

Exp Date:

Instructions: FAA STC SR01583SE 18/12/17, TC STC SH05-

130 Packaging 3-1 - Stock - B4B 1 pcs	6/26/19	0.00 0.00	QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	DAS 28 9-89
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	6/26/19	0.00 0.00	DC - 1 - B4B
				DC - 2 - B4B
140 QC 21 - FG	1 pcs	6/26/19	0.00 0.00	QC 21 - FG - 21
				QC 21 - FG - 70
				QC 21 - FG - 53

Part Op 110 - (Assemble as per dwg) 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure Descriptions: tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/-291 5163437
 Expiry date: 10-12-8 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/R Sikaflex-241/-291 5163437 Expiry date: 10-12-8 3-Remove "T" pins once sikaflex is dry. 4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon 14133640 VERIFY FWD AND AFT SADDLE FIT DURING ASSEMBLY
 BY: S.C DATE: 19/06/17
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D412-742-043
 Location: _____ PPP Rev: _____
 135 - If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG007
 140 - (QC21- Final Inspection - Work Order Release)

Fg dock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C4A	Bolt	24 Ea (24 ea)	110-Handfinish - 4 - Assembly	5143675
AN3C6A	Bolt	4 Ea (4 ea)	110-Handfinish - 4 - Assembly	5174235
AN5C7A	Bolt	10 Ea (10 ea)	110-Handfinish - 4 - Assembly	5079115
D3391-021	Fwd Tube Assembly	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5135725
D3391-023	Mld Tube Assembly	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5174777
D3391-025	Aft Tube Assembly	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5157827
D4095-041	Wearplate Fwd	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5072731
D4095-043	Wearplate Aft	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5059995
D4095-045	Wearplate Center	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5041025
NAS1149C0332R	Washer	28 Ea (28 ea)	110-Handfinish - 4 - Assembly	5158078
NAS1149C0532R	Washer	10 Ea (10 ea)	110-Handfinish - 4 - Assembly	5014735

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Handfinish - 4 - Assembly	AN3C4A	24	790	0
	AN3C6A	4	201	0
	AN5C7A	10	102	0
	D3391-021	1	3	0
	D3391-023	1	5	0
	D3391-025	1	5	0
	D4095-041	1	10	0
	D4095-043	1	13	0
	D4095-045	1	5	0
	NAS1149C0332R	28	2,658	0
	NAS1149C0532R	10	204	0

Part Specifications

Specifications could not be found.

Plex 6/12/19 11:12 AM Dart.lajeunesse.marie

Chantal Lavoie

From: McMaster-Carr <cle.sales@mcmaster.com>
Sent: Wednesday, June 12, 2019 8:24 AM
To: Chantal Lavoie
Subject: RE: infp
Attachments: image001.jpg; image002.jpg; image003.jpg

Hi Chantal,

The EPDM foam sheet with a material certificate (8647K999) is \$5.82 per foot and can ship in 2-3 weeks. The material certificate is only available for a 6 ft. length. Please reference quotation number 65899 when placing your order.

Angie

From: cle.sales@mcmaster.com
Sent: Tuesday, June 11, 2019 3:52 PM
To: Chantal Lavoie <clavoie@dartaero.com>
Subject: RE: infp

Hi Chantal,

The supplier is closed for the day. We will have an answer for you tomorrow.

Andre

From: Chantal Lavoie <clavoie@dartaero.com>
Sent: Tuesday, June 11, 2019 2:19 PM
To: 'McMaster-Carr' <cle.sales@mcmaster.com>
Subject: infp

Good afternoon,

Please advise if it's possible to get a material certification for the following item.

8647K21

<https://www.mcmaster.com/catalog/125/3713>

Thanks

Chantal

Chantal Lavoie

Purchasing Coordinator

DART AEROSPACE

T 1 613 632-5200

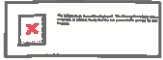
F 1 613 632-1053

E clavoie@dartaero.com

1 800 556- 4166

www.dartaerospace.com

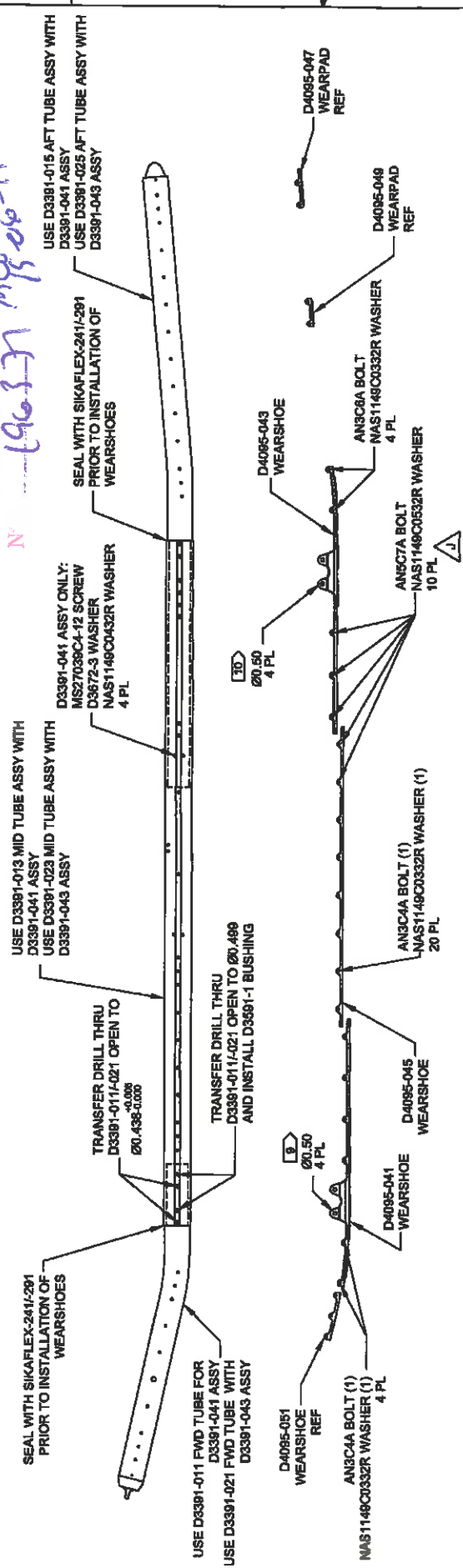
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NOTICE

WORK ORDER
N 196371 MY 26-11



D3391-041/-043 ASSY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME PER DART QSI 005 4.2.1.3.3 PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 8.6
 - 7) WEIGHT: N/A
 - 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
 - 9) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
 - 10) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

DESIGN	PH	ML	CP	REV. J
DRAWN				
CHECKED				
ENG. APPR.				
APPROVED				
DE APPR.				
DATE	16.01.14			

RELEASED
R 2016-04-28

DART AEROSPACE USA, INC
EUGENE, OR

DRAWING NO. D3391
SHEET 2 OF 11
TITLE 412 FLOAT SKIDTUBE
SCALE NTS

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS																																																																																											
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																																																																					
Date : _____		Sequence #: _____		QTY Affected : _____		MIRB (QSI042)																																																																																									
Description Work Order Deviation				Disposition																																																																																											
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>				Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>☐</td><td>Contamination</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Bending</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Tolerance</td><td>☐</td></tr><tr><td>Crushing</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain Direction</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td><td>Incomplete/Unclear Instructions</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Mislabeled</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Off-set/Set-up</td><td>☐</td><td></td><td></td></tr><tr><td colspan="8">Other/Details:</td><td colspan="2"></td><td colspan="2"></td></tr></table>								Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐			Other/Details:											
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